# Work Order ID 98208

*98208*



*March-08-13 2:34:45 PM*

**Item ID:** D350-636-011
**Revision ID:**
**Item Name:** Skidtube LH

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

**Start Date:** 3/08/13 **Start Qty:** 1.00 *1*
**Required Date:** 3/22/13 **Req'd Qty:** 1.00 *1*
**Reference:**

**Cust Item ID:**
**Customer:**

Run Start *NR1*
Stop *NR2*

**Approvals:** **Process Plan:** MLS **Date:** 13-03-08 **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| Draw Nbr: D2750 | Revision Nbr: F | | | | | | | | |
| 100 | DOCUMENT CONTROL | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| DC | **Memo** | 0.00 | | | | | | | |
| Document Control | Photocopy blue file and type labels per PPP D350-636-011 CHG 006 | | | | | | | | |

27
3-4-17

MLS 13-4-11

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

# Work Order ID 98208

*March-08-13 2:34:45 PM*

*98208*



**Item ID:** D350-636-011 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Start Qty:** 1.00 *1* **Cust Item ID:**

**Required Date:** 3/22/13 **Req'd Qty:** 1.00 *1* **Customer:**

**Reference:**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 110 | | 0.00 | | | | | | | |
| *110* | Skidtubes | | | | | | | | |
| Skidtubes | | 0.00 | | | | | | | |
| Skidtubes | | | | | | | | | |

**Memo**

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***

8-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

BE 13-03-11

- DC 13/03/12

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under-tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

# Work Order ID 98208

*March-08-13 2:34:45 PM*

*98208*



**Item ID:** D350-636-011 **Accept** *N9000040100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Start Qty:** 1.00 *1*

**Required Date:** 3/22/13 **Req'd Qty:** 1.00 *1*

**Reference:**

**Cust Item ID:**

**Customer:**

**Run Start** *NR1*

**Stop** *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| | 11-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004<br>A/R Aluminum Rod batch: M128399 BE 13-03-11<br><br>12-Grind welds flush as per Dwg D2750 | | | | | | | | |
| 120<br>*120*<br>QC<br>Quality Control | QC10- Inspect visual per QSI004- ground welds<br><br>**Memo** | 0.00<br>0.00 | | | | | | | DAS 16 9-8 13/3/12 |
| 130<br>*130*<br>QC<br>Quality Control | QC5- Inspect part completeness to step on W/O<br><br>**Memo** | 0.00<br>0.00 | | | | | | | DAS 16 9-8 13/3/12 |

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

# Work Order ID 98208

*March-08-13 2:34:45 PM*

*98208*

**Item ID:** D350-636-011
**Revision ID:**
**Item Name:** Skidtube LH

**Accept** *N9000040100*

**Setup Start** *NS1*
**Stop** *NS2*

**Start Date:** 3/08/13 **Start Qty:** 1.00 *1*
**Required Date:** 3/22/13 **Req'd Qty:** 1.00 *1*
**Reference:**

**Cust Item ID:**
**Customer:**

**Run Start** *NR1*
**Stop** *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 140 | Chemical Conversion Coat per QSI005 4.1 | 0.00 | | | | | | | |
| *140* | | | | | | 1 | SAD | 13-03-19 | |
| HandFinish | **Memo** | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |
| 150 | QC7-Inspect Chemical Conversion Coat | 0.00 | | | | | | | |
| *150* | | | | | | 1 | 0 | 13-03-19 | DAS 18 |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | |
| Operator | | | | | | | | | | |
| Material | | | | | | | | | | |
| Setup | | | | | | | | | | |
| Other | | | | | | | | | | |
| Process | | | | | | | | | | |
| Supplier | | | | | | | | | | |
| Training | | | | | | | | | | |
| Unapproved | | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

**Work Order ID 98208**

*March-08-13 2:34:45 PM*

*98208*

**Item ID:** D350-636-011

**Revision ID:**

**Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Start Qty:** 1.00 *1*

**Required Date:** 3/22/13 **Req'd Qty:** 1.00 *1*

**Reference:**

**Accept** *N900040100*

**Setup Start** *NS1*

**Stop** *NS2*

**Cust Item ID:**

**Customer:**

**Run Start** *NR1*

**Stop** *NR2*

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 160 | | 0.00 | | | | 1 | | | |
| *160* | Skidtubes | | | | | | | | |
| Skidtubes | | 0.00 | | | | | | | |
| Skidtubes | | | | | | | | | |

**Memo**

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750 (welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

SAD 13-03-19

7-Bond web D2739 in place as per QSI 015
A/R Sikaflex-291 batch: 123944
exp. date: 13/06/22 - DC 13/03/20

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)
A/R Aluminum Rod batch: M122324 - DC 13/03/21

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750 SAD 13-03-21

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

## FAULT CATEGORY

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

# Work Order ID 98208

*March-08-13 2:34:45 PM*

*98208*

**Item ID:** D350-636-011 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Start Qty:** 1.00 *1*

**Required Date:** 3/22/13 **Req'd Qty:** 1.00 *1*

**Reference:**

**Cust Item ID:**

**Customer:**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Run Start** *NR1*

**Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| | 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 | | | | | | | | |
| | 12-Deburr holes | | | | | | | | |
| 170 *170* QC Quality Control | QC10- Inspect visual per QSI004- ground welds | 0.00 | | | | 1 | | | |
| | **Memo** | 0.00 | | | | 13-03-25 | | | DAS 09 |
| 180 *180* QC Quality Control | QC5- Inspect part completeness to step on W/O | 0.00 | | | | 1 | | | |
| | **Memo** ***VERIFY C'BOARD IS GOOD*** | 0.00 | | | | | | | |

DAS 21

B3 21

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

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# Work Order ID 98208

*March-08-13 2:34:45 PM*

*98208*

**Item ID:** D350-636-011 **Accept** *N9000040100* **Setup Start** *NS1*
**Revision ID:** **Stop** *NS2*
**Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Start Qty:** 1.00 *1*
**Required Date:** 3/22/13 **Req'd Qty:** 1.00 *1*
**Reference:**

**Cust Item ID:**
**Customer:**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Run Start** *NR1*
**Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 190 | Pressure Wash per QSI005 4.3 | 0.00 | | | | 1 | 76 | 13-43 | |
| *190* | | | | | | | | | |
| HandFinish | **Memo** | 0.00 | | | | | | | |
| Hand Finishing | Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch. | | | | | | | | |
| 200 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | | | | 1 x y | | 13/04/04 | |
| *200* | | | | | | | | | |
| Powdercoat | **Memo** | 0.00 | | | | | | | |
| Powder Coating | START TIME: 1:40 OVEN TEMPERATURE: 320°F FINISH TIME: 2:10 | | | | | | | | |
| m124275 | | | | | | | | | |
| 210 | QC3- Inspect Part Finish | 0.00 | | | | 1 h 4 | | 13/04/04 | |
| *210* | | | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | ✓ Inspect for foreign object per QSI 024 | | | | | | | | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

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# Work Order ID 98208

*March-08-13 2:34:45 PM*

*98208*



**Item ID:** D350-636-011 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Start Qty:** 1.00 *1*

**Required Date:** 3/22/13 **Req'd Qty:** 1.00 *1*

**Reference:**

**Cust Item ID:**

**Customer:**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Run Start** *NR1*

**Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 220 | | 0.00 | | | | | | | |
| *220* | HandFinishing | | | | | 1441 | 4 | M | 13/04/05 |
| HandFinish | **Memo** | 0.00 | | | | | | | |
| Hand Finishing | 1- Install inserts as per Dwg D2750 | | | | | | | | |
| 230 | | 0.00 | | | | | | | |
| *230* | HandFinishing | | | | | 1441 | 4 | DW | 13/04/05 |
| HandFinish | **Memo** | 0.00 | | | | | | | |
| Hand Finishing | 1-Inspect for Foreign Objects | | | | | | | | |

2-Spray inside of tube with "LPS-3" batch: 814

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750
SIKA FLEX 241
BATCH: M12344
EXP DATE: 1306

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: M12165

5-Coat all exposed fasteners with "LPS Procyon" batch: M11455

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

# Work Order ID 98208

*March-08-13 2:34:45 PM*

*98208*

**Item ID:** D350-636-011 **Accept** *N900040100* **Setup Start** *NS1*

**Revision ID:** **Stop** *NS2*

**Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Start Qty:** 1.00 *1*

**Required Date:** 3/22/13 **Req'd Qty:** 1.00 *1*

**Reference:**

**Cust Item ID:**

**Customer:**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Run Start** *NR1*

**Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 240 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | 1 | | | |
| *240* | | | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 250 | Pick Kit | 0.00 | | | | | | | |
| *250* | | | | | | | | | |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 260 | QC4- 100% Inspect kits for completeness | 0.00 | | | | 1 | | | |
| *260* | | | | | | | | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | ******ensure antiseize is on AN8C21A bolts******* | | | | | | | | |

DAS 27 B45

3/4/11

DAS 27 B47

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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# Work Order ID 98208

*March-08-13 2:34:45 PM*

*98208*



**Item ID:** D350-636-011
**Revision ID:**
**Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Start Qty:** 1.00 *1*
**Required Date:** 3/22/13 **Req'd Qty:** 1.00 *1*
**Reference:**

**Accept** *N900040100*

**Setup Start** *NS1*
**Stop** *NS2*

**Cust Item ID:**
**Customer:**

**Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
**QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Run Start** *NR1*
**Stop** *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|---|---|---|---|---|---|---|---|
| 270 | | 0.00 | | | | | | | |
| *270* | Packaging | | | | | 1 | 8 | 13-4-17 | |
| Packaging | **Memo** | 0.00 | | | | | | | |
| Packaging | Package as per PPP D350-636-011 REV. J | | | | | | | | |
| 280 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *280* | | | | | | | 13/4/22 | | |
| QC | **Memo** | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

13-04-17

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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# Picklist Print

*March-08-13 2:34:49 PM*



**Work Order ID:** 98208

*98208*

**Parent Item:** D350-636-011

*D350-636-011*

**Parent Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Required Date:** 3/22/13

**Start Qty:** 1.00 **Required Qty:** 1.00

**Comments:**

IPP Rev:I 02.09.25 Rearranged procedure steps KJ
IPP Rev:J 06-03-23 As per Rev D JLM
IPP Rev:K 06-07.13 As per dsi9343 EC
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
DD verf:EC IPP Rev:P 10.06.22 revise
seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| D3492-1 | | Manufactured | No | | | 230 | Each | 126.0000 | 8 | 8 | | | |

*D3492-1*

Plug

**

| Location | Loc Qty | Loc Code |
|---|---|---|
| FP001 | 126 | |
| 69531 | 8 | |
| 74444 | 2 | |
| 76235 | 4 | |
| 83098 | 7 | |
| 88541 | 3 | |
| 91466 | 2 | |
| 96226 | 60 | |
| 97266 | 40 | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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# Picklist Print

*March-08-13 2:34:49 PM*

**Work Order ID:** 98208

*98208*

**Parent Item:** D350-636-011

*D350-636-011*

**Parent Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Required Date:** 3/22/13

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| D3492-3 | Manufactured | No | | 230 | Each | 119.0000 | 8 | 8 | |
| *D3492-3* | | | | | | ** | | | 13/04/60 |
| Plug | | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FP001 | 119 | | |
| 81967 | 5 | | |
| 83099 | 3 | | |
| 85461 | 1 | | |
| 86865 | 2 | | |
| 95124 | 108 | | X8 |

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| NAS1611-010 | Purchased | No | | 230 | Each | 401.0000 | 8 | 8 | |
| *NAS1611-010* | | | | | | ** | | | 13/04/60 |
| O-RING | | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FP001 | 401 | | |
| 110915 | 14 | | |
| 117460 | 8 | | |
| 118077 | 1 | | |
| 118612 | 3 | | |
| 119438 | 7 | | |
| 121259 | 2 | | |
| 121584 | 2 | | |
| 121723 | 7 | | |
| 122151 | 8 | | |
| 123348 | 29 | | |
| 123352 | 4 | | |
| 124580 | 316 | | X8 |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | |
| Operator | | | | | | | | | | |
| Material | | | | | | | | | | |
| Setup | | | | | | | | | | |
| Other | | | | | | | | | | |
| Process | | | | | | | | | | |
| Supplier | | | | | | | | | | |
| Training | | | | | | | | | | |
| Unapproved | | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

# Picklist Print

*March-08-13 2:34:49 PM*

**Work Order ID:** 98208

*98208*

**Parent Item:** D350-636-011

*D350-636-011*

**Parent Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Required Date:** 3/22/13

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| NAS1149D0863J | Purchased | No | | 250 | Each | 124.0000 | 1 2 | 2 |
| *NAS1149D0863J* | | | | | | | ** | |
| WASHER | | | | | | | | |

SHO

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FP001 | 16 | | |
| 118078 | 16 | | |
| ST294 | 108 | | |
| 121556 | 8 | | |
| 123900 | 100 | | 1239W |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D2744 | Manufactured | No | | 110 | Each | 44.0000 | 1 | 1 |
| *D2744* | | | | | | | ** | BEG-03-11 |
| Cap | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| LG | 43 | | |
| 94647 | 20 | | |
| 95089 | 23 | | 1 |
| LG002 | 1 | | |
| 62715 | 1 | | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D2600-3-BENT | Manufactured | No | | 110 | Each | 30.0000 | 1 | 1 |
| *D2600-3-BENT* | | | | | | | ** | BEG-03-11 |
| Extrusion Bent | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| LG | 30 | | |
| 66875 | 7 | | |
| 73253 | 1 | | |
| 75021 | 1 | | |
| 75022 | 1 | | |
| 75023 | 1 | | |
| 81330 | 4 | | |
| 83305 | 1 | | |
| 95212 | 14 | | 1 |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outsidé Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

# Picklist Print

*March-08-13 2:34:49 PM*

**Work Order ID:** 98208

*98208*

**Parent Item:** D350-636-011

*D350-636-011*

**Parent Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Required Date:** 3/22/13

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D2743 | Manufactured | No | | 160 | Each | 140.0000 | 8 | 8 |

*D2743*

Crossbolt Spacer

**

BE13/03/21
B97584 *8

| Location | Loc Qty | Loc Code |
|---|---|---|
| LG001 | 74 | |
| 67766 | 4 | |
| 68251 | 3 | |
| 73403 | 64 | |
| 74445 | 1 | |
| 79517 | 2 | |
| LG002 | 66 | |
| 81965 | 23 | |
| 83262 | 2 | |
| 85459 | 4 | |
| 88504 | 2 | |
| 95148 | 2 | |
| 95901 | 33 | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D2739 | Manufactured | No | | 160 | Each | 9.0000 | 1 | 1 |

*D2739*

350 I Beam

**

DC13/03/20

| Location B97618 | Loc Qty | Loc Code |
|---|---|---|
| LG | 9 | |
| 72155 | 1 | |
| 81508 | 1 | |
| 85487 | 1 | |
| 87734 | 1 | |
| 95218 | 1 | |
| 97319 | 4 | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

# Picklist Print

*March-08-13 2:34:49 PM*

**Work Order ID:** 98208

*98208*

**Parent Item:** D350-636-011

*D350-636-011*

**Parent Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Required Date:** 3/22/13

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D3490-3 | Manufactured | No | 160 | Each | 48.0000 | 4 | 4 | |
| *D3490-3* | | | | | ** | | | BE 3/03/21 |
| Cross Bolt Spacer | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| LG | 4 | | |
| 92443 | 1 | | |
| 95223 | 3 | | |
| LG001 | 44 | | |
| 93438 | 44 | | 4 |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D3490-1 | Manufactured | No | 160 | Each | 55.0000 | 4 | 4 | |
| *D3490-1* | | | | | ** | | | BE 3/03/21 |
| Cross Bolt Spacer | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| LG001 | 51 | | |
| 62450 | 2 | | |
| 74875 | 4 | | |
| 77042 | 3 | | |
| 95977 | 42 | | 4 |
| LG004 | 4 | | |
| 81976 | 2 | | |
| 94805 | 2 | | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

# Picklist Print

*March-08-13 2:34:49 PM*

**Work Order ID:** 98208

*98208*

**Parent Item:** D350-636-011

*D350-636-011*

**Parent Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Required Date:** 3/22/13

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| ALS4-1032-225 | Purchased | No | | 220 | Each | 2,529.000 | 38 | 38 | 13/04/04 |
| *ALS4-1032-225* | | | | | | | ** | | |
| Insert | | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FP001 | 1089 | | |
| 118386 | 55 | | |
| 118966 | 68 | | |
| 120410 | 10 | | |
| 120451 | 13 | | |
| 121269 | 77 | | |
| 122827 | 866 | | |
| ST280 | 1440 | | |
| 118520 | 440 | | |
| 124468 | 1000 | | X38 |

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| D3793-3 | Manufactured | No | | 230 | Each | 19.0000 | 1 | 1 | |
| *D3793-3* | | | | | | | ** | | 13/04/04 |
| Wearshoe | | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FP001 | 1 | | |
| 92487 | 1 | | |
| FP002 | 18 | | |
| 94972 | 18 | | X1 |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

## FAULT CATEGORY

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

# Picklist Print

*March-08-13 2:34:49 PM*

**Work Order ID:** 98208

*98208*

**Parent Item:** D350-636-011

*D350-636-011*

**Parent Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Required Date:** 3/22/13

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| AN8C35A | Purchased | No | | 230 | Each | 88.0000 | 1 | | |
| *AN8C35A* | | | | | | | ** | JH 13/04/04 | |
| BOLT | | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FG | 5 | | |
| 121275 | 5 | | |
| FP001 | 8 | | |
| 115960 | 1 | | |
| 121275 | 1 | | |
| 123642 | 6 | | |
| st507 | 75 | | |
| 124827 | 75 | | X1 |

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| D3793-1 | Manufactured | No | | 230 | Each | 19.0000 | 1 | 1 | |
| *D3793-1* | | | | | | | ** | JH 13/04/04 | |
| Wearshoe | | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FP002 | 19 | | |
| 82171 | 2 | | |
| 87273 | 3 | | |
| 92382 | 1 | | |
| 95017 | 13 | | X1 |

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| D3488-041 | Manufactured | No | | 230 | Each | 7.0000 | 1 | 1 | |
| *D3488-041* | | | | | | | ** | JH 13/04/04 | |
| Blade Fitting Assembly, LH | | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FP002 | 7 | | |
| 95014 | 7 | | X1 |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

# Picklist Print

*March-08-13 2:34:49 PM*

**Work Order ID:** 98208

*98208*

**Parent Item:** D350-636-011

*D350-636-011*

**Parent Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Required Date:** 3/22/13

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D3794-3 | Manufactured | No | | 230 | Each | 23.0000 | 1 | JH 13/04/08 |
| *D3794-3* | | | | | | | ** | |
| Gasket | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FP001 | 23 | | |
| 74530 | 2 | | |
| 92658 | 1 | | |
| 94544 | 12 | | |
| 94997 | 8 | | X1 |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| AN6C44A | Purchased | No | | 230 | Each | 125.0000 | 4 | 4 |
| *AN6C44A* | | | | | | | ** | JH 13/04/08 |
| BOLT | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FG | 2 | | |
| 103964 | 2 | | |
| ST341 | 123 | | |
| 124623 | 123 | | X4 |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| MS21083C8 | Purchased | No | | 230 | Each | 119.0000 | 1 | 1 |
| *MS21083C8* | | | | | | | ** | JH 13/04/08 |
| NUT | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| ST319 | 19 | | |
| 123900 | 3 | | |
| 124291 | 16 | | X1 |
| ST506 | 100 | | |
| 124308 | 100 | | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

# Picklist Print

*March-08-13 2:34:49 PM*

**Work Order ID:** 98208

*98208*

**Parent Item:** D350-636-011

*D350-636-011*

**Parent Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Required Date:** 3/22/13

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D3536-25 | Manufactured | No | | 230 | Each | 31.0000 | 1 | 1 |

*D3536-25*

Gasket

**

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FG | 2 | | |
| 87053 | 2 | | |
| FP001 | 29 | | |
| 83900 | 1 | | |
| 89057 | 1 | | |
| 93696 | 1 | | |
| 95328 | 25 | | X1 |
| 95686 | 1 | | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D3631-1 | Manufactured | No | | 230 | Each | 295.0000 | 8 | 8 |

*D3631-1*

Washer

**

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FP001 | 280 | | |
| 81874 | 2 | | |
| 83588 | 18 | | |
| 91606 | 1 | | |
| 94702 | 59 | | X2 |
| 97193 | 200 | | X6 |
| FP002 | 15 | | |
| 68062 | 2 | | |
| 75548 | 13 | | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

# Picklist Print

*March-08-13 2:34:49 PM*

**Work Order ID:** 98208

*98208*

**Parent Item:** D350-636-011

*D350-636-011*

**Parent Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Required Date:** 3/22/13

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| D3791-1 | | Manufactured | No | | 230 | Each | 13.0000 | 1 | 1 | |
| *D3791-1* | | | | | | | | ** | M 13/04/04 | |
| Wearplate | | | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FP002 | 13 | | |
| 62239 | 2 | | |
| 83392 | 1 | | |
| 95099 | 10 | | X1 |

| | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| AN960C10L | NAS1149C0332R | Purchased | No | | 230 | Each | 0.0000 | 38 | 38 | |
| *AN960C10L* | | | | | | | M124580 | ** | (x38) M 13/04/04 | |
| washer | | | | | | | | | | |
| D2745 | | Manufactured | No | | 230 | Each | 199.0000 | 8 | 8 | |
| *D2745* | | | | | | | | ** | M 13/04/04 | |
| Bushing | | | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FP001 | 10 | | |
| 69529 | 1 | | |
| 76142 | 1 | | |
| 79518 | 6 | | |
| 83260 | 2 | | |
| FP-001 | 1 | | |
| 92539 | 1 | | |
| ST017 | 188 | | |
| 94715 | 40 | | |
| 95125 | 65 | | |
| 95878 | 43 | | |
| 97205 | 40 | | X8 |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

# Picklist Print

*March-08-13 2:34:49 PM*

**Work Order ID:** 98208

*98208*

**Parent Item:** D350-636-011

*D350-636-011*

**Parent Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Required Date:** 3/22/13

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| AN3C5A | Purchased | No | | 230 | Each | 1,801.000 | 34 | 34 | |
| *AN3C5A* | | | | | | | ** | yl | 13/04/01 |
| Bolt | | | | | | | | | |

| Location | | Loc Qty | Loc Code | |
|---|---|---|---|---|
| FG | | 5 | | |
| | 122800 | 5 | | |
| ST350 | | 28 | | |
| | 116419 | 28 | | |
| ST512 | | 1768 | | |
| | 124221 | 1768 | | X34 |

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| D3537-1 | Manufactured | No | | 230 | Each | 59.0000 | 3 | 3 | |
| *D3537-1* | | | | | | | ** | yl | 13/03/04 |
| Wearpad | | | | | | | | | |

| Location | | Loc Qty | Loc Code | |
|---|---|---|---|---|
| FG | | 20 | | |
| | 79833 | 10 | B97603 | X3 |
| | 88562 | 10 | | |
| FP001 | | 39 | | |
| | 83254 | 1 | | |
| | 83255 | 3 | | |
| | 87697 | 1 | | |
| | 88562 | 9 | | |
| | 91668 | 24 | | |
| | 94395 | 1 | | |

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| NAS1149C0832R | Purchased | No | | 230 | Each | 201.0000 | 1 | 1 | |
| *NAS1149C0832R* | | | | | | | ** | yl | 13/04/04 |
| WASHER | | | | | | | | | |

| Location | | Loc Qty | Loc Code | |
|---|---|---|---|---|
| FP001 | | 1 | | |
| | 114915 | 1 | | |
| ST292 | | 200 | | |
| | 122441 | 200 | | VI |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

## FAULT CATEGORY

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

# Picklist Print

*March-08-13 2:34:49 PM*

**Work Order ID:** 98208

*98208*

**Parent Item:** D350-636-011

*D350-636-011*

**Parent Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Required Date:** 3/22/13

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| AN3C6A | Purchased | No | | 230 | Each | 454.0000 | 4 | 4 |
| *AN3C6A* | | | | | | | ** | JM 13/04/05 |
| BOLT | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FG | 10 | | |
| 122416 | 10 | | |
| FP001 | 172 | | |
| 122599 | 172 | | XY |
| FP002 | 1 | | |
| 111982 | 1 | | |
| ST351 | 271 | | |
| 122416 | 271 | | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| NAS1611-013 | Purchased | No | | 230 | Each | 325.0000 | 8 | 8 |
| *NAS1611-013* | | | | | | | ** | JM 13/04/05 |
| O-RING | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FP001 | 325 | | |
| 116582 | 5 | | |
| 117291 | 2 | | |
| 117887 | 53 | | |
| 119623 | 36 | | |
| 121825 | 10 | | |
| 122993 | 3 | | |
| 124231 | 1 | | |
| 124670 | 215 | | YE |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | |
| Operator | | | | | | | | | | |
| Material | | | | | | | | | | |
| Setup | | | | | | | | | | |
| Other | | | | | | | | | | |
| Process | | | | | | | | | | |
| Supplier | | | | | | | | | | |
| Training | | | | | | | | | | |
| Unapproved | | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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# Picklist Print

*March-08-13 2:34:49 PM*

**Work Order ID:** 98208

*98208*

**Parent Item:** D350-636-011

*D350-636-011*

**Parent Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Required Date:** 3/22/13

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| D3535-25 | Manufactured | No | | 230 | Each | 32.0000 | 1 | 1 | |
| *D3535-25* | | | | | | | ** | | |
| Wearshoe | | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FP002 | 32 | | |
| 62233 | 1 | | |
| 81357 | 1 | | |
| 87385 | 1 | | |
| 90061 | 1 | | |
| 95077 | 28 | | X1 |

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| D3794-1 | Manufactured | No | | 230 | Each | 31.0000 | 1 | 1 | |
| *D3794-1* | | | | | | | ** | | |
| Gasket | | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FP001 | 31 | | |
| 87631 | 2 | | |
| 92426 | 1 | | |
| 95155 | 15 | | X1 |
| 95913 | 13 | | |

| | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| MS21043-6 | Purchased | No | | 230 | Each | 494.0000 | 4 | 4 | |
| *MS21043-6* | | | | | | | ** | | |
| NUT | | | | | | | | | |

| Location | Loc Qty | Loc Code | |
|---|---|---|---|
| FG | 20 | | |
| 103693 | 20 | | |
| ST315 | 314 | | |
| 117887 | 2 | | |
| 120308 | 172 | | X1 |
| 124231 | 140 | | |
| ST506 | 160 | | |
| 124485 | 160 | | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

## FAULT CATEGORY

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

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# Picklist Print

*March-08-13 2:34:49 PM*

**Work Order ID:** 98208 *98208*

**Parent Item:** D350-636-011 *D350-636-011*

**Parent Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Required Date:** 3/22/13

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | |
|---|---|---|---|---|---|---|
| D3493-1 *D3493-1* Washer | Manufactured | No | 250 | Each | 100.0000 | 2 (2) ** |

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST052 | 100 | |
| 94711 | 40 | |
| 95120 | 6 | |
| 97201 | 24 | |
| 97568 | 30 | |

***ONLY INSTALL IF INSTALLING ON APICAL FLOAT SYSTEM***

| | | | | | | |
|---|---|---|---|---|---|---|
| MS21083C8 *MS21083C8* NUT | Purchased | No | 250 | Each | 119.0000 | 2 (2) ** |

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST319 | 19 | |
| 123900 | 3 | |
| 124291 | 16 | |
| ST506 | 100 | |
| 124308 | 100 | |

| | | | | | | |
|---|---|---|---|---|---|---|
| AN8C21A *AN8C21A* BOLT | Purchased | No | 250 | Each | 8.0000 | 2 (2) ** |

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST342 | 8 | |
| 123966 | 8 | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | ☐ | | | | | | | | | |
| Equip/Tooling | ☐ | | | | | | | | | |
| Operator | ☐ | | | | | | | | | |
| Material | ☐ | | | | | | | | | |
| Setup | ☐ | | | | | | | | | |
| Other | ☐ | | | | | | | | | |
| Process | ☐ | | | | | | | | | |
| Supplier | ☐ | | | | | | | | | |
| Training | ☐ | | | | | | | | | |
| Unapproved | ☐ | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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# Picklist Print

*March-08-13 2:34:49 PM*

**Work Order ID:** 98208

*98208*

**Parent Item:** D350-636-011

*D350-636-011*

**Parent Item Name:** Skidtube LH

**Start Date:** 3/08/13 **Required Date:** 3/22/13

**Start Qty:** 1.00 **Required Qty:** 1.00

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| NAS1515H3L | Purchased | No | | 230 | Each | 677.0000 | 4 | 4 |

*NAS1515H3L*

WASHER

**

| Location | Loc Qty | Loc Code |
|---|---|---|
| FG | 40 | |
| 102472 | 40 | |
| ST297 | 637 | |
| 121556 | 45 | |
| 124542 | 592 | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D2741 | Manufactured | No | | 250 | Each | 17.0000 | 1 | 1 |

*D2741*

Blade, 350 Skidtube

**

SM

| Location | Loc Qty | Loc Code |
|---|---|---|
| FG | 2 | |
| 85480 | 2 | |
| ST466 | 15 | |
| 71856 | 1 | |
| 85480 | 1 | |
| 93852 | 13 | |

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| D3532-1 | Manufactured | No | | 250 | Each | 33.0000 | 2 | 2 |

*D3532-1*

Spacer

**

SM

| Location | Loc Qty | Loc Code |
|---|---|---|
| ST055 | 33 | |
| 95181 | 14 | |
| 95942 | 19 | |

DQA: _____ Date: _____

NCR: Yes / No

# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

**DISPOSITION**

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

**AGAINST DEPARTMENT/PROCESS**

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

| Root Cause | | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---|---|---|---|---|---|---|---|---|---|---|
| Doc/Data | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | |
| Operator | | | | | | | | | | |
| Material | | | | | | | | | | |
| Setup | | | | | | | | | | |
| Other | | | | | | | | | | |
| Process | | | | | | | | | | |
| Supplier | | | | | | | | | | |
| Training | | | | | | | | | | |
| Unapproved | | | | | | | | | | |

**FAULT CATEGORY**

**Landing Gear**

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

**General**

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

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| | QTY -041 | QTY -042 | QTY -043 | QTY -044 | PART NUMBER | DESCRIPTION |
|---|---|---|---|---|---|---|
| | X | | | | D2750-041 | 350 SKIDTUBE ASSEMBLY, LH |
| | | X | | | D2750-042 | 350 SKIDTUBE ASSEMBLY, RH |
| | | | X | | D2750-043 | 350 SKIDTUBE ASSEMBLY, LH |
| | | | | X | D2750-044 | 350 SKIDTUBE ASSEMBLY, RH |
| | | | | | | |
| | 1 | 1 | 1 | 1 | D2739 | WEB |
| | 8 | 8 | 8 | 8 | D2743 | SPACER |
| | 1 | 1 | 1 | 1 | D2744 | CAP |
| | 8 | 8 | 8 | 8 | D2745 | BUSHING |
| | 1 | | | | D2750-1 | SKIDTUBE WELDMENT, LH |
| | | 1 | | | D2750-2 | SKIDTUBE WELDMENT, RH |
| | | | 1 | | D2750-3 | SKIDTUBE WELDMENT, LH |
| | | | | 1 | D2750-4 | SKIDTUBE WELDMENT, RH |
| | 1 | | 1 | | D3488-041 | BLADE FITTING, LH |
| | | 1 | | 1 | D3488-042 | BLADE FITTING, RH |
| | 4 | 4 | 4 | 4 | D3490-1 | SPACER |
| | 4 | 4 | | | D3490-3 | SPACER |
| | | | 4 | 4 | D3490-5 | SPACER |
| | 8 | 8 | 8 | 8 | D3492-041 | PLUG ASSEMBLY |
| | 8 | 8 | | | D3492-043 | PLUG ASSEMBLY |
| | | | 8 | 8 | D3492-045 | PLUG ASSEMBLY |
| | 1 | 1 | 1 | 1 | D3535-25 | WEARSHOE |
| | 1 | 1 | 1 | 1 | D3536-25 | GASKET |
| F | 3 | 3 | 3 | 3 | D3537-1 | WEARPAD |
| | 8 | 8 | 8 | 8 | D3631-1 | WASHER |
| | 1 | 1 | 1 | 1 | D3791-1 | WEARPLATE |
| | 1 | 1 | 1 | 1 | D3793-1 | WEARSHOE |
| F | 1 | 1 | 1 | 1 | D3793-3 | WEARSHOE |
| | 1 | 1 | 1 | 1 | D3794-1 | GASKET |
| | 1 | 1 | 1 | 1 | D3794-3 | GASKET |
| | | | | | | |
| F | 38 | 38 | 38 | 38 | ALS4-1032-225 | INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225) |
| | 34 | 34 | 34 | 34 | AN3C5A | BOLT |
| | 4 | 4 | 4 | 4 | AN3C6A | BOLT |
| | 4 | 4 | 4 | 4 | AN6C44A | BOLT |
| | 1 | 1 | 1 | 1 | AN8C35A | BOLT |
| F | 38 | 38 | 38 | 38 | AN960C10L | WASHER |
| | 1 | 1 | 1 | 1 | AN960C816L | WASHER |
| | 4 | 4 | 4 | 4 | MS21043-6 | NUT |
| | 1 | 1 | 1 | 1 | MS21083C8 | NUT |
| | 4 | 4 | 4 | 4 | NAS1515H3L | WASHER |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 98208 MCJ
13-03-08

RELEASED
05.23.12 MD

**GENERAL NOTES:**

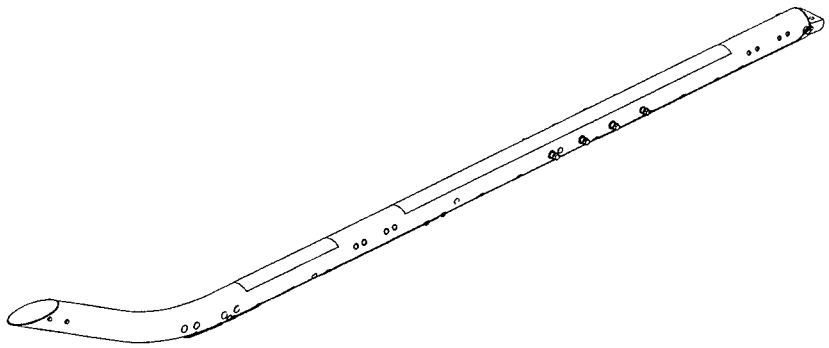
1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
2) FINISH:
   ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
   POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
8) WELD PER DART QSI 004
9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
    MINIMUM YIELD TENSILE STRENGTH = 35 KSI
    MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL (F)
13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

| REV. | DESCRIPTION | BY | DATE |
|---|---|---|---|
| F | INCORPORATE DSI 9413:<br>QTY (3) D3537-1 WAS QTY (5) (ZN C8-1);<br>D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1);<br>D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1);<br>ADD D3791-1 (ZN C8-1);<br>WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE QTY UPDATED (ZN B8-1);<br>D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11);<br>ADD NOTE 12 AND 13 (ZN A6-1);<br>REASON: REF. NCN 08-043 | PH | 08.07.16 |
| E | CHANGE TO STAINLESS STEEL WEARPLATES;<br>ADD RUBBER GASKETS, CHANGE INSERTS, ADD D3631-1;<br>REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8 | CB | 07.05.17 |
| D | ADD HOLES AND SPACERS FOR APICAL FLOATS;<br>INCORPORATE DEO 9133/9157 | PH | 06.01.05 |
| C | ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740 | CP | 98.11.18 |
| B | CHANGE MS24694-S293 TO AN8-16A | CP | 98.09.01 |
| A | NEW ISSUE | DS | 98.04.16 |

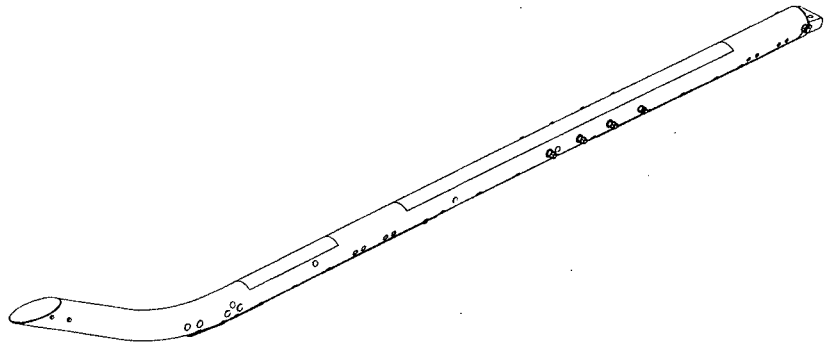
| | | |
|---|---|---|
| DESIGN | PH | DART AEROSPACE USA, INC. |
| DRAWN | RH | PORT HADLOCK, WA |
| CHECKED | | DRAWING NO. D2750 REV. F |
| MFG. APPR. | | SHEET 1 OF 11 |
| APPROVED | | TITLE 350 SKIDTUBE ASSEMBLY SCALE NTS |
| DE APPR. | | |
| DATE | 08.07.16 | |

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98208



D2750-041 350 SKIDTUBE ASSEMBLY, LH



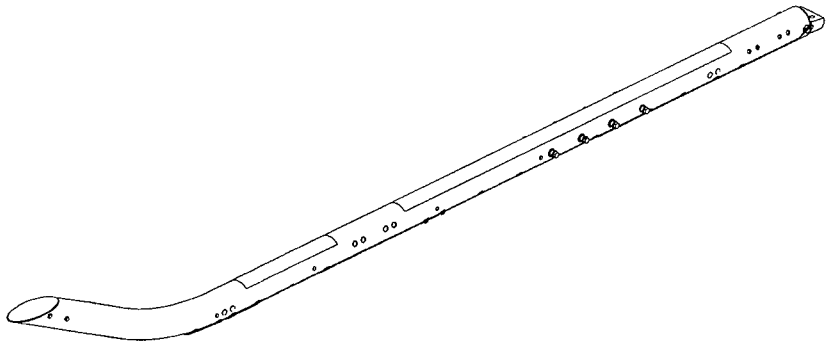
D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
07.22.16

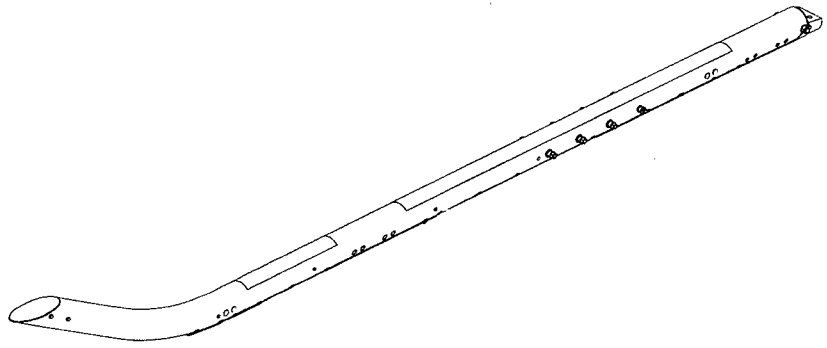
| | | | |
|---|---|---|---|
| DESIGN | PW | DART AEROSPACE USA, INC. | |
| DRAWN | PW | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2750 | SHEET 2 OF 11 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 350 SKIDTUBE ASSEMBLY | NTS |
| DATE | 08.07.16 | | |

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98208



D2750-043 350 SKIDTUBE ASSEMBLY, LH



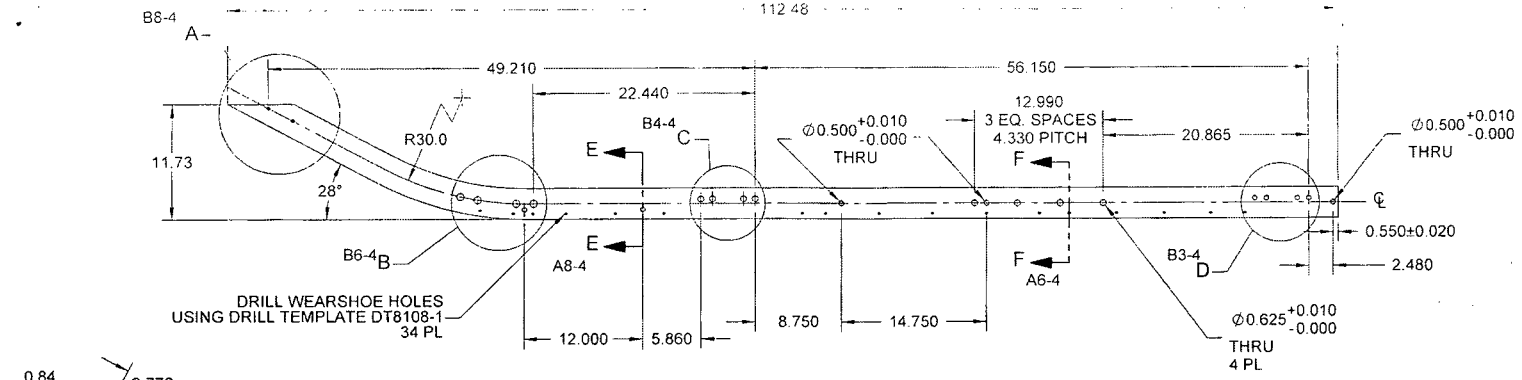
D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
05-9.22

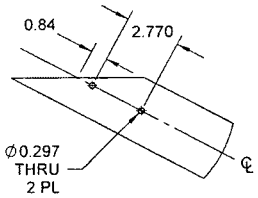
| | | | |
|---|---|---|---|
| DESIGN | PD | DART AEROSPACE USA, INC. | |
| DRAWN | PD | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. D2750 | REV. F |
| MFG. APPR. | | | SHEET 3 OF 11 |
| APPROVED | | TITLE 350 SKIDTUBE ASSEMBLY | SCALE NTS |
| DE APPR. | | | |
| DATE 08.07.16 | | | |

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98208

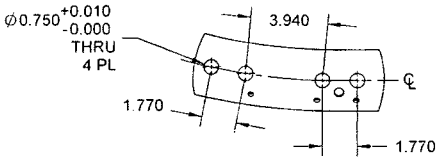



## D2750-1 LH SKIDTUBE



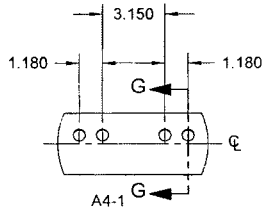

D7-4

**DETAIL A**
SCALE 2X



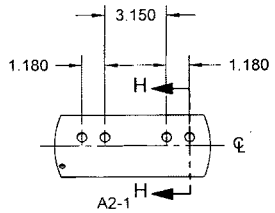

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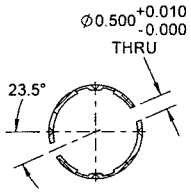

D5-4

**DETAIL C**
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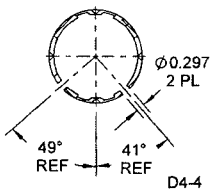

D3-4

**DETAIL D**
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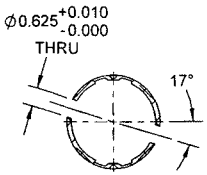

D6-4

**SECTION E-E**
SCALE 3X, 2 PL



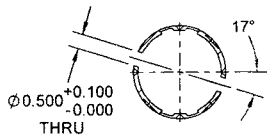

D4-4

**SECTION F-F**
SCALE 3X, 17 PL




B4-4

**SECTION G-G**
SCALE 3X, 4 PL




B2-4

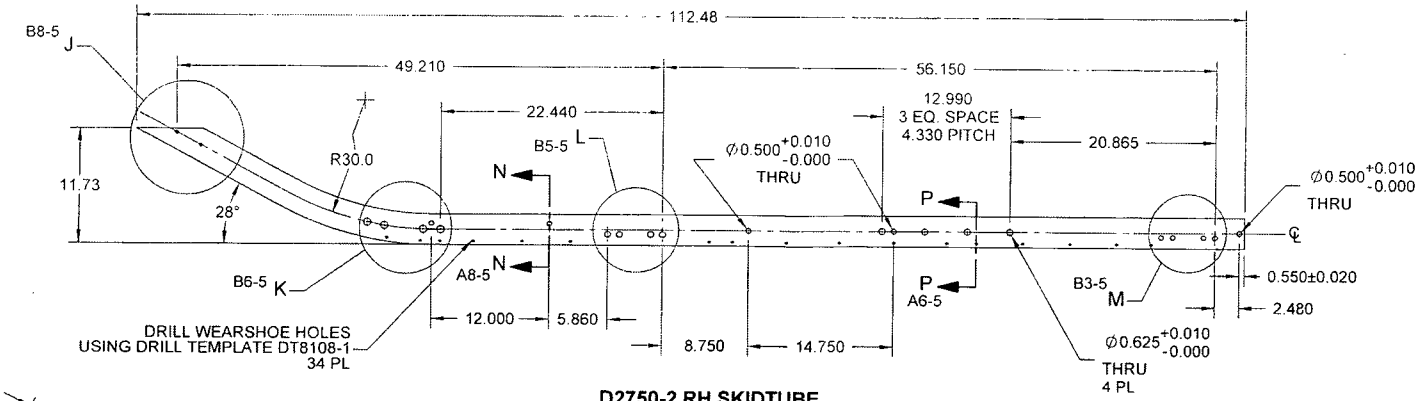
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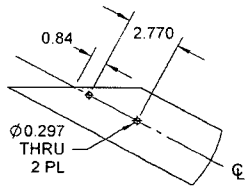
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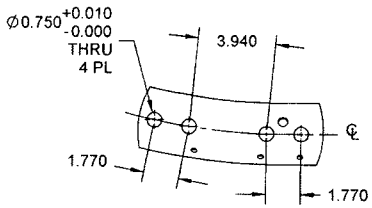



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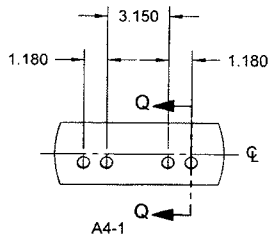

D8-5

**DETAIL J**
SCALE 2X



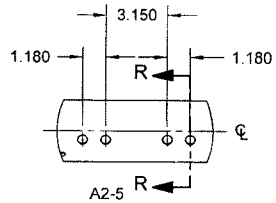

C7-5

**DETAIL K**
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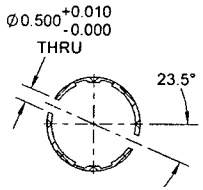

D6-5

**DETAIL L**
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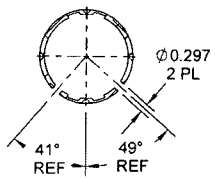

C3-5

**DETAIL M**
SCALE 2X



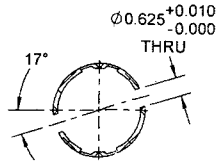

C6-5

**SECTION N-N**
SCALE 3X, 2 PL



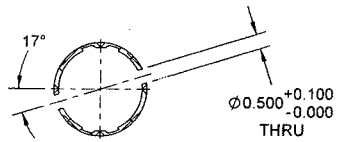

C4-5

**SECTION P-P**
SCALE 3X, 17 PL




B5-5

**SECTION Q-Q**
SCALE 3X, 4 PL




B3-5

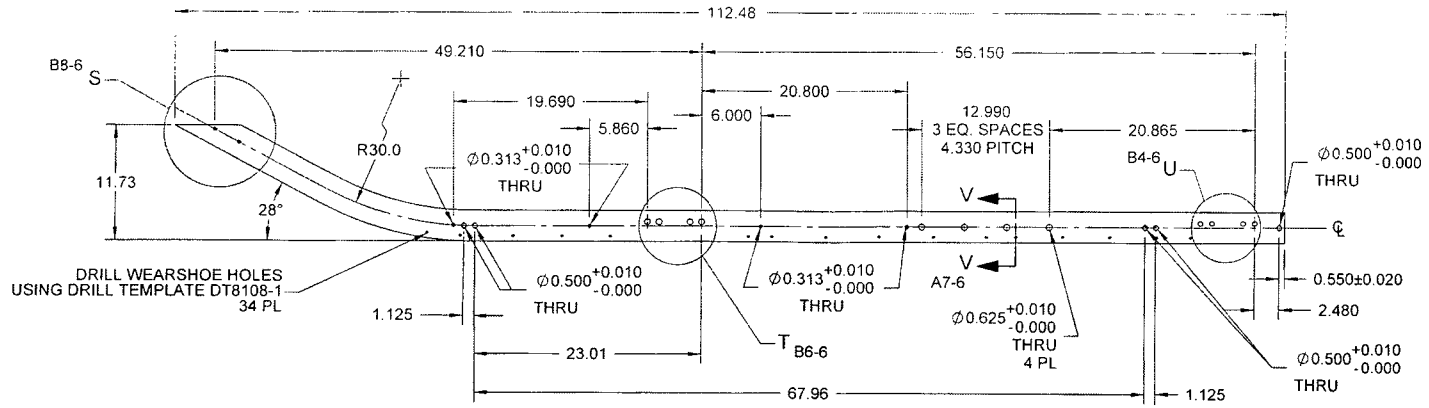
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08/22/16

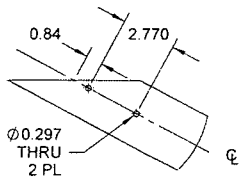
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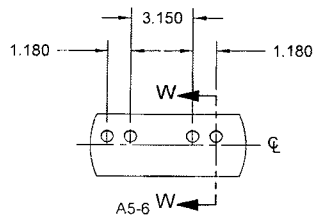
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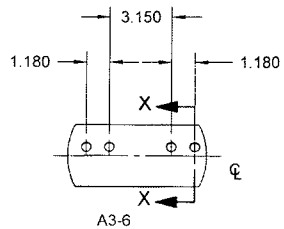

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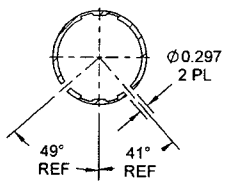

**DETAIL S** D8-6
SCALE 2X



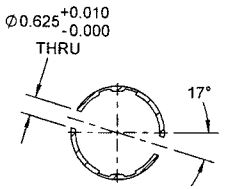

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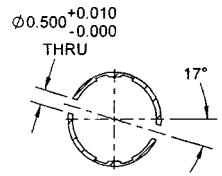

**DETAIL U** D3-6
SCALE 2X




**SECTION V-V** C4-6
SCALE 3X, 17 PL




**SECTION W-W** B6-6
SCALE 3X, 4 PL



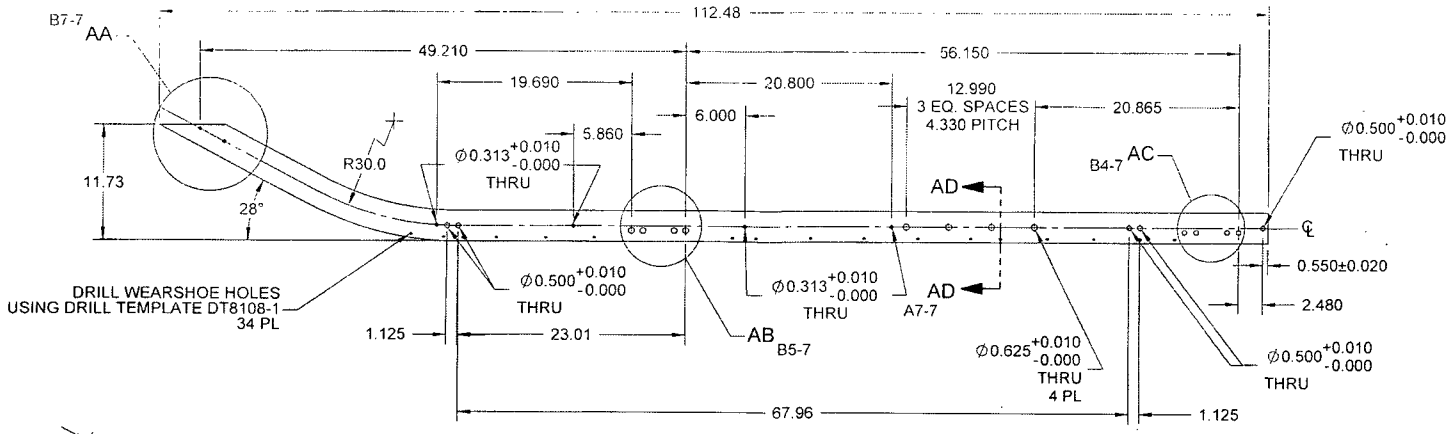

**SECTION X-X** B4-6
SCALE 3X, 4 PL

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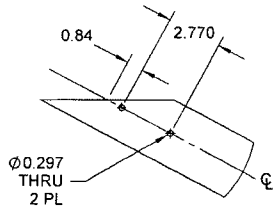
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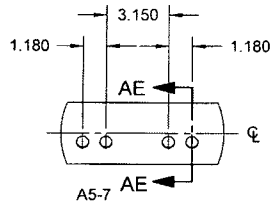
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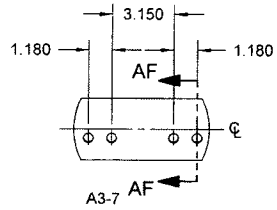

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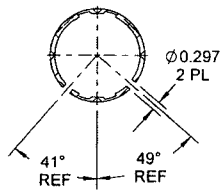

**DETAIL AA** D7-7
SCALE 2X



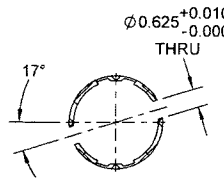

**DETAIL AB** C4-7
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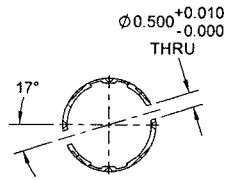

**DETAIL AC** D3-7
SCALE 2X




**SECTION AD-AD** D3-7
SCALE 3X, 17 PL




**SECTION AE-AE** B6-7
SCALE 3X, 4 PL



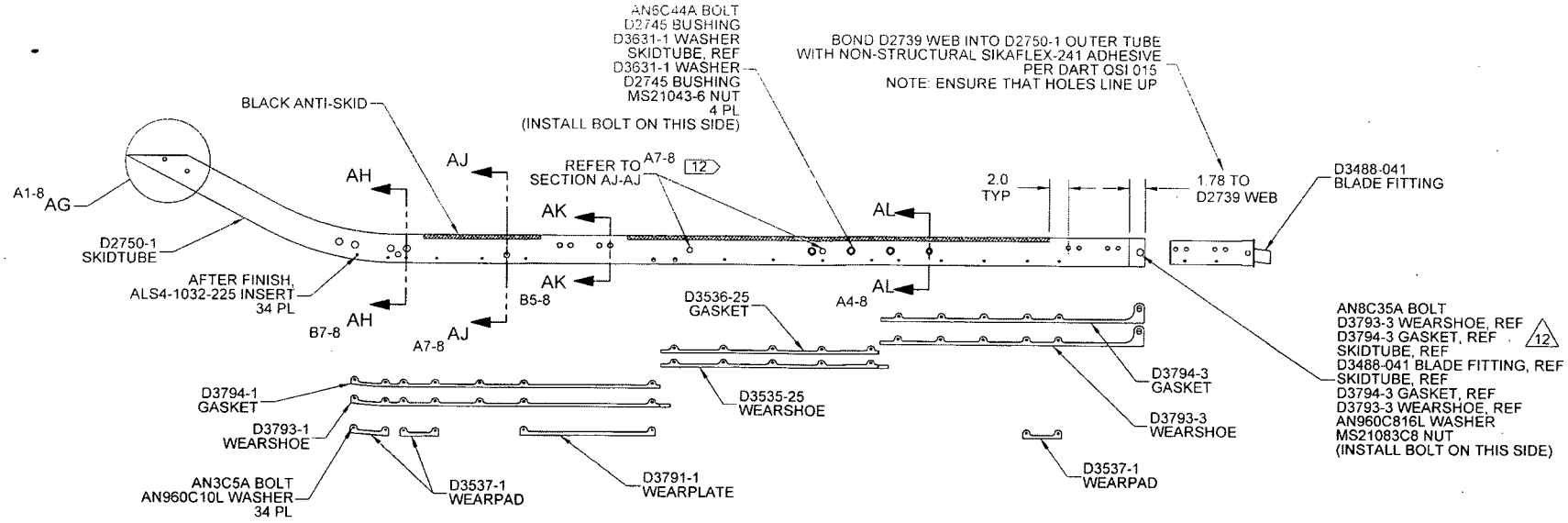

**SECTION AF-AF** B4-7
SCALE 3X, 4 PL

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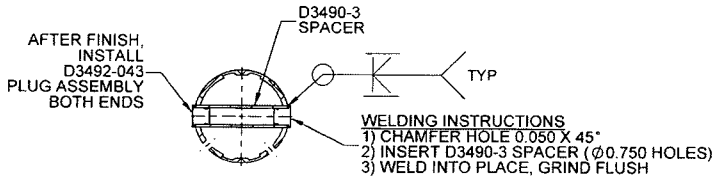
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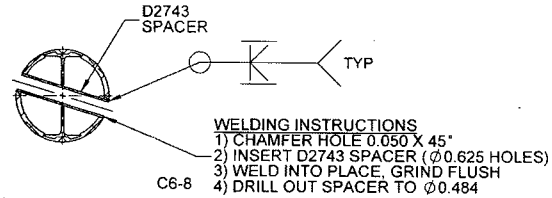
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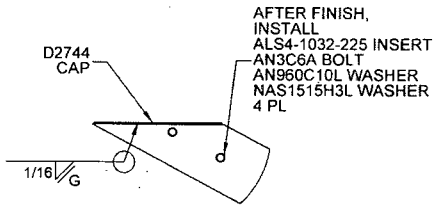

## D2750-041 350 SKIDTUBE ASSEMBLY, LH




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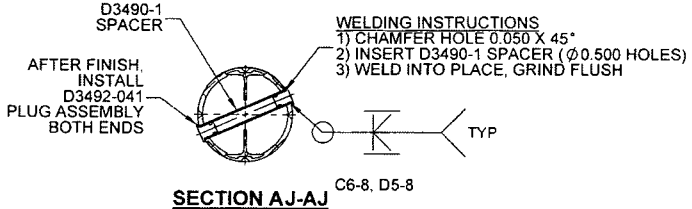



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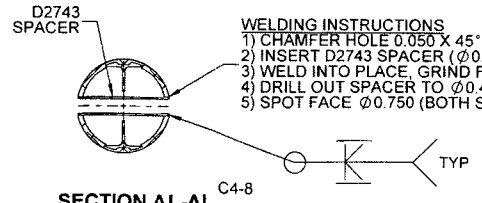



**DETAIL AG**
SCALE 2X

D8-8




**SECTION AJ-AJ**
SCALE 3X, 4 PL



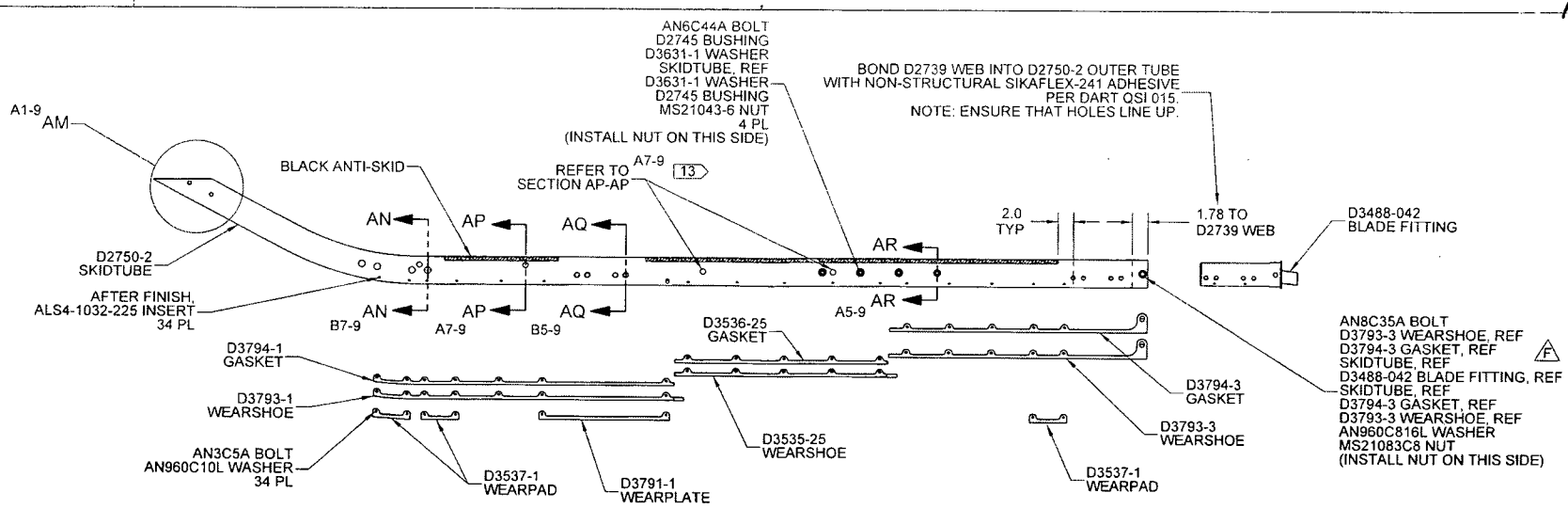

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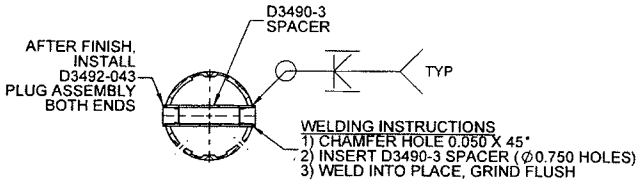
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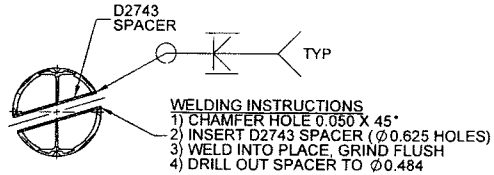
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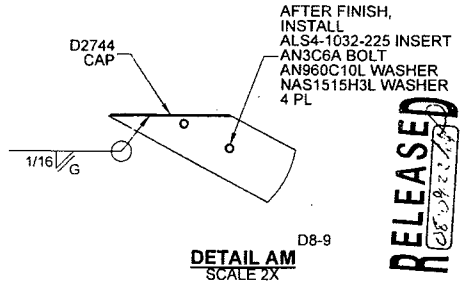

## D2750-042 350 SKIDTUBE ASSEMBLY, RH



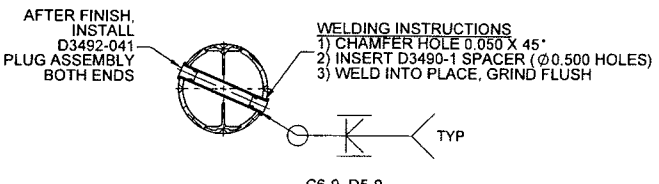

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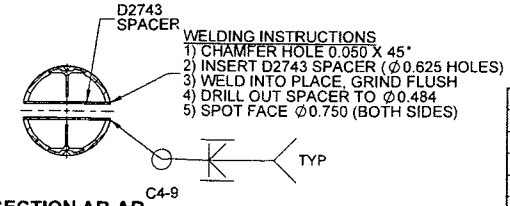

**SECTION AQ-AQ**
SCALE 3X, 4 PL




**DETAIL AM**
SCALE 2X




**SECTION AP-AP**
SCALE 3X, 4 PL



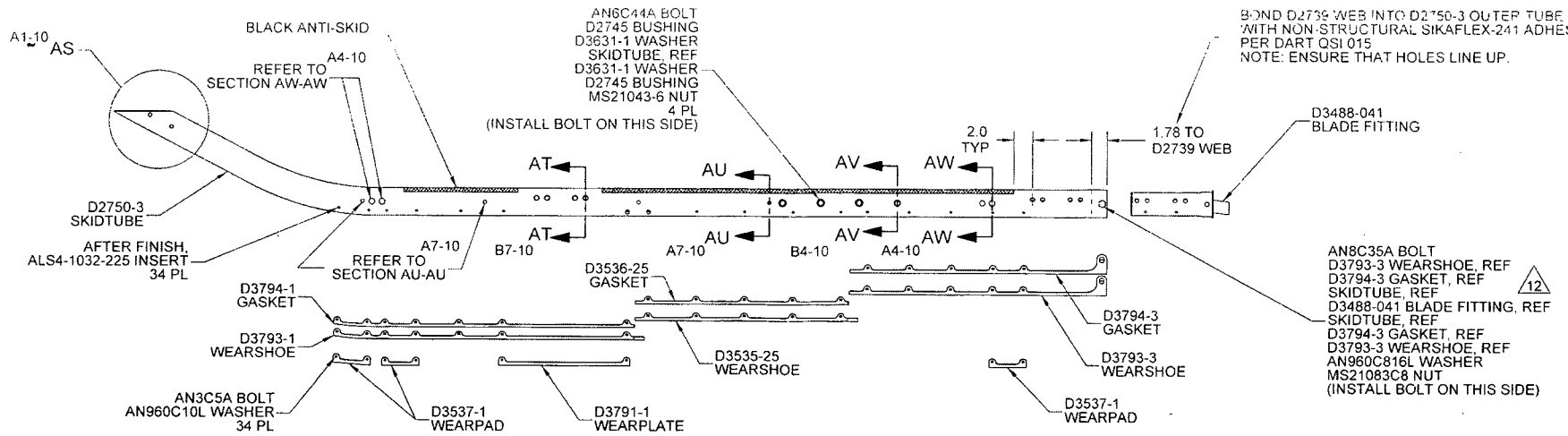

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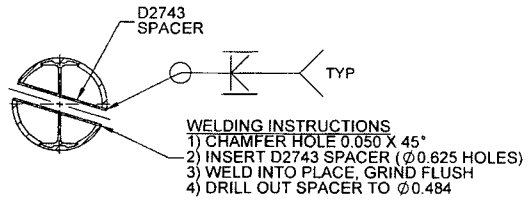
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98208

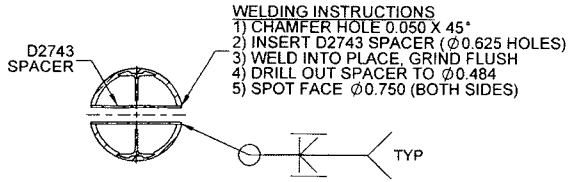



## D2750-043 350 SKIDTUBE ASSEMBLY, LH



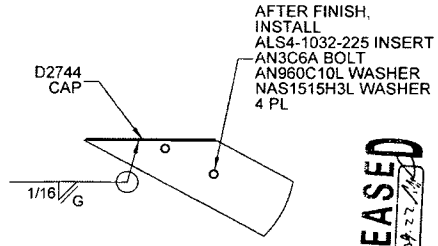

D6-10

**SECTION AT-AT**
SCALE 3X, 4 PL



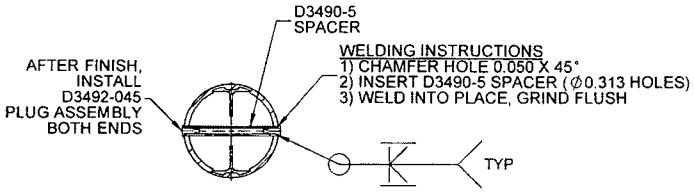

D4-10

**SECTION AV-AV**
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



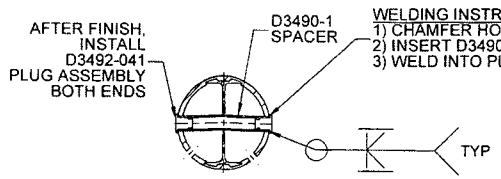

D8-10

**DETAIL AS**
SCALE 2X




D5-10, D6-10

**SECTION AU-AU**
SCALE 3X, 4 PL




D4-10, D7-10

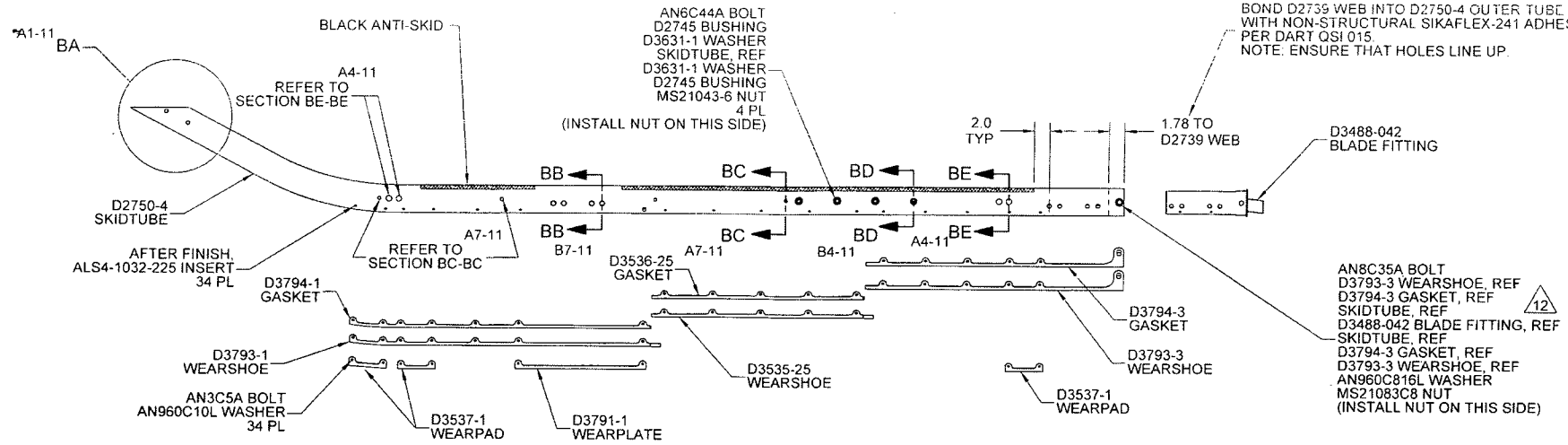
**SECTION AW-AW**
SCALE 3X, 4 PL

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DART QSI 22.1

| | | |
|---|---|---|
| DESIGN | | DART AEROSPACE USA, INC. PORT HADLOCK, WA |
| DRAWN | | |
| CHECKED | | DRAWING NO. D2750 REV. F |
| MFG. APPR. | | SHEET 10 OF 11 |
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| DE APPR. | | |
| DATE 08.07.16 | | |

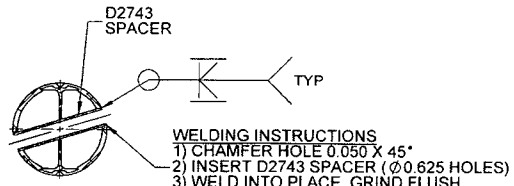
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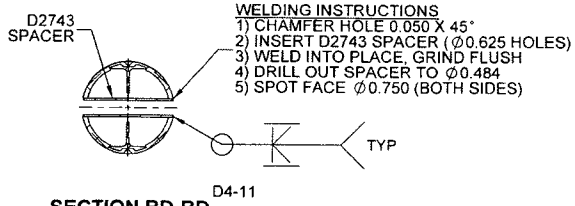



## D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
08.09.22

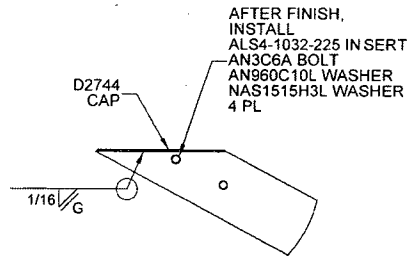



**SECTION BB-BB** D6-11
SCALE 3X, 4 PL

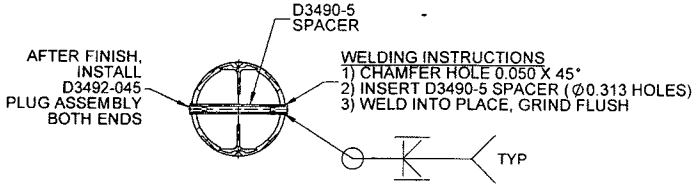



D4-11

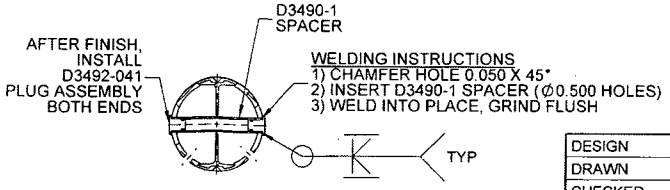
**SECTION BD-BD**
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)




**DETAIL BA** D8-11
SCALE 2X




**SECTION BC-BC** D5-11, C6-11
SCALE 3X, 4 PL




D4-11, D7-11

**SECTION BE-BE**
SCALE 3X, 4 PL

| | | |
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| DE APPR. | | |
| DATE | 08.07.16 | |

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NO. 316

# AWS D17.1.2001
## QUALIFICATION TEST RECORD

**Name:** Barclay Elliott
**Job #:** 97399
**Part #:** D350-626-016
**Description:** 350 skid tube
**Welding Process:** Tig[✓] Mig[ ]
**Base materiel:** Aluminum
**Current:** AC[✓] DC[ ]

## TEST REQUIREMENTS AND RESULTS

| | |
|---|---|
| **Visual:** | pass[✓] fail[ ] |
| **Incomplete Penetration:** | pass[✓] fail[ ] |
| **Incomplete Fusion:** | pass[✓] fail[ ] |
| **Cracks:** | pass[✓] fail[ ] |
| **Overlap (cold lap)** | pass[✓] fail[ ] |
| **Undercut:** | pass[✓] fail[ ] |
| **Pin holes:** | pass[✓] fail[ ] |
| **Porosity (surface):** | pass[✓] fail[ ] |
| **Coloration:** | pass[✓] fail[ ] |
| **Burn through:** | pass[✓] fail[ ] |

**Qualifier** DMS 09 **Date of Test Coupon** 13-03-13

**Welder** Barclay Elliott **Date of Test Coupon** 13-03-13

The above named individual is qualified in accordance with AWS D17.1.2001 to weld